FIG. 1 (a)

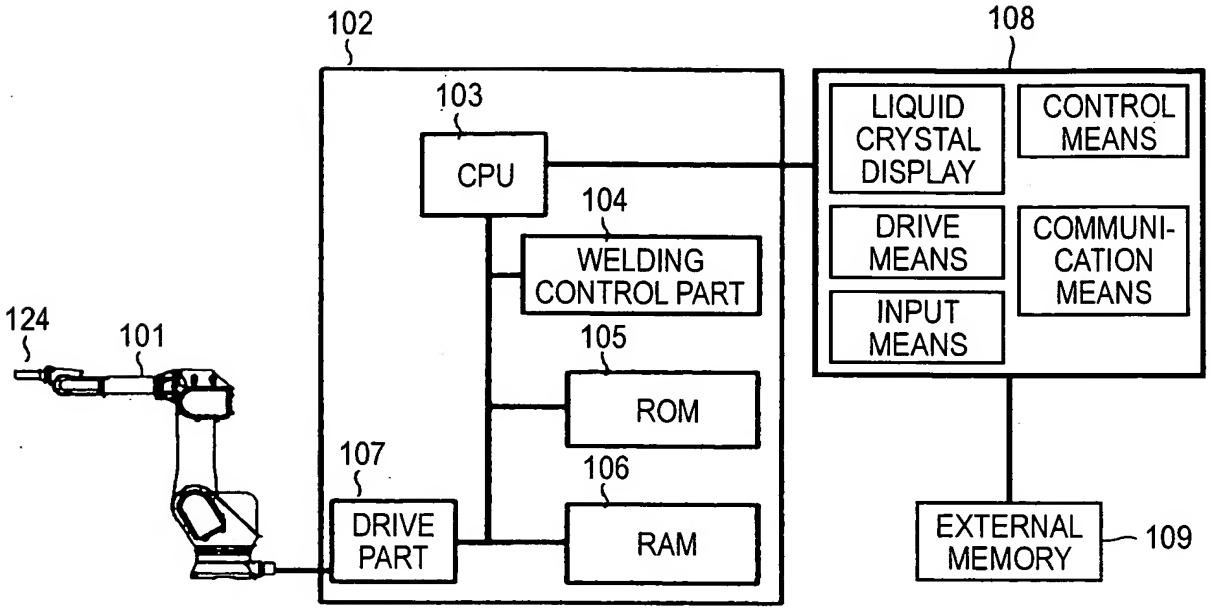

102
108
103
CPU
LIQUID CRYSTAL DISPLAY
CONTROL MEANS
104
WELDING CONTROL PART
DRIVE MEANS
COMMUNI-CATION MEANS
INPUT MEANS
124
101
105
ROM
107
106
DRIVE PART
RAM
EXTERNAL MEMORY
109

FIG. 1 (b)

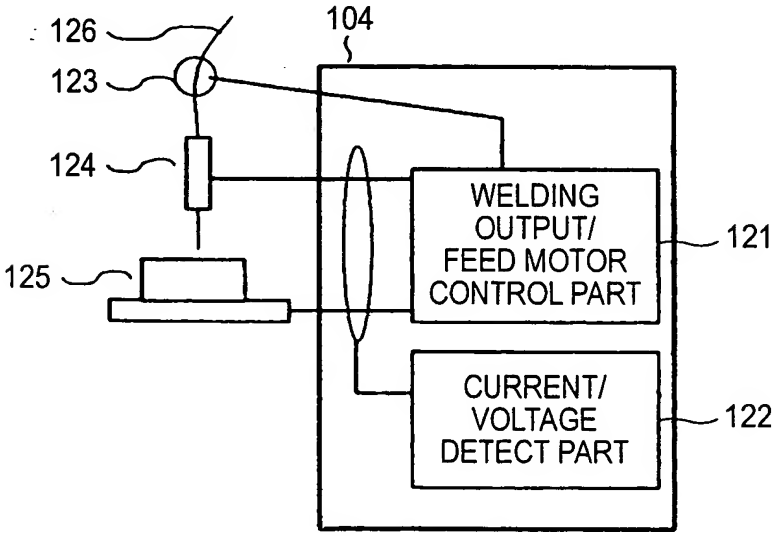

126
104
123
124
WELDING OUTPUT/ FEED MOTOR CONTROL PART
121
125
CURRENT/ VOLTAGE DETECT PART
122

FIG. 2

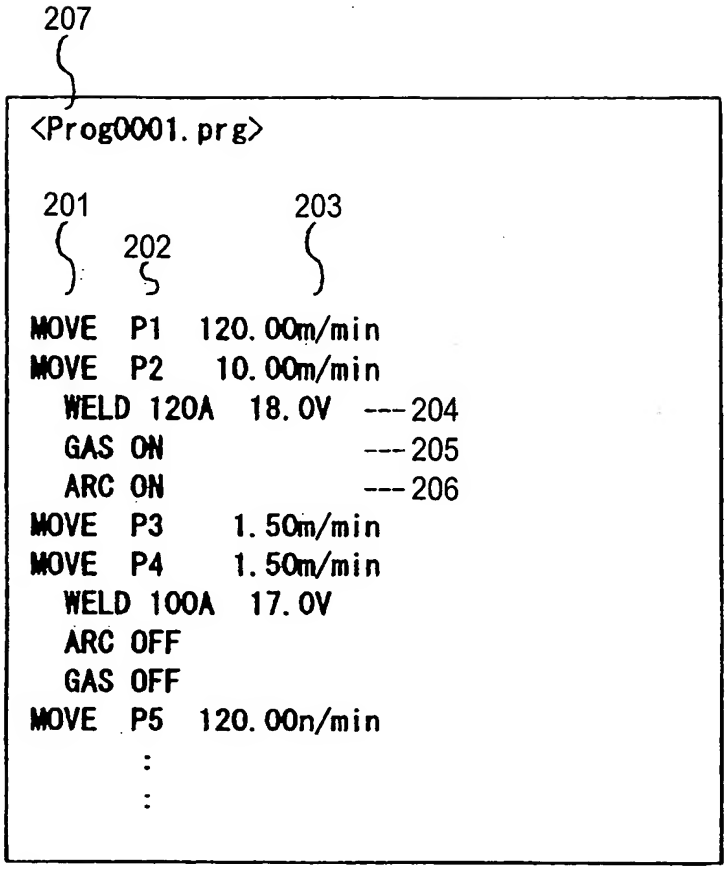

207
<Prog0001.prg>
201
202
203
MOVE P1 120.00m/min
MOVE P2 10.00m/min
WELD 120A 18.0V ---204
GAS ON ---205
ARC ON ---206
MOVE P3 1.50m/min
MOVE P4 1.50m/min
WELD 100A 17.0V
ARC OFF
GAS OFF
MOVE P5 120.00n/min
:
:

FIG. 3

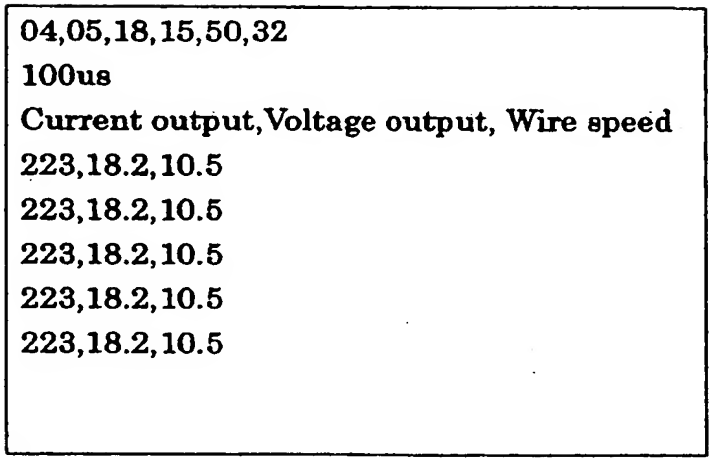

04,05,18,15,50,32
100us
Current output,Voltage output, Wire speed
223,18.2,10.5
223,18.2,10.5
223,18.2,10.5
223,18.2,10.5
223,18.2,10.5

FIG. 4

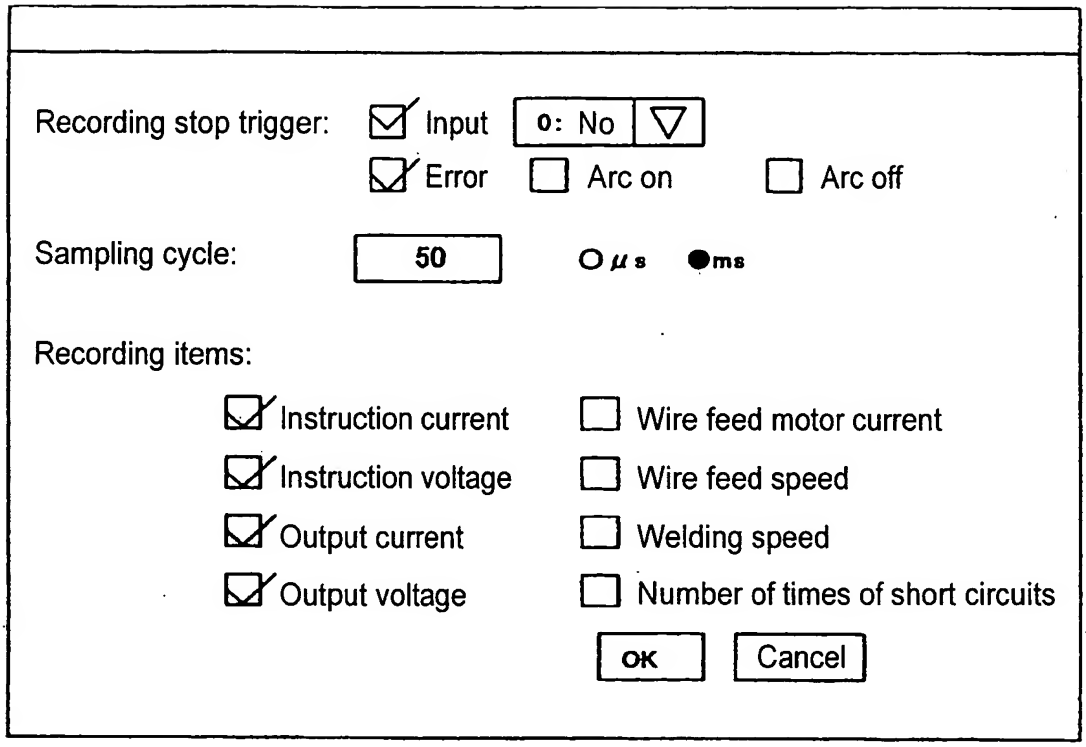

Recording stop trigger:
Input
0: No
Error
Arc on
Arc off
Sampling cycle:
50
μs
ms
Recording items:
Instruction current
Instruction voltage
Output current
Output voltage
Wire feed motor current
Wire feed speed
Welding speed
Number of times of short circuits
OK
Cancel

FIG. 5

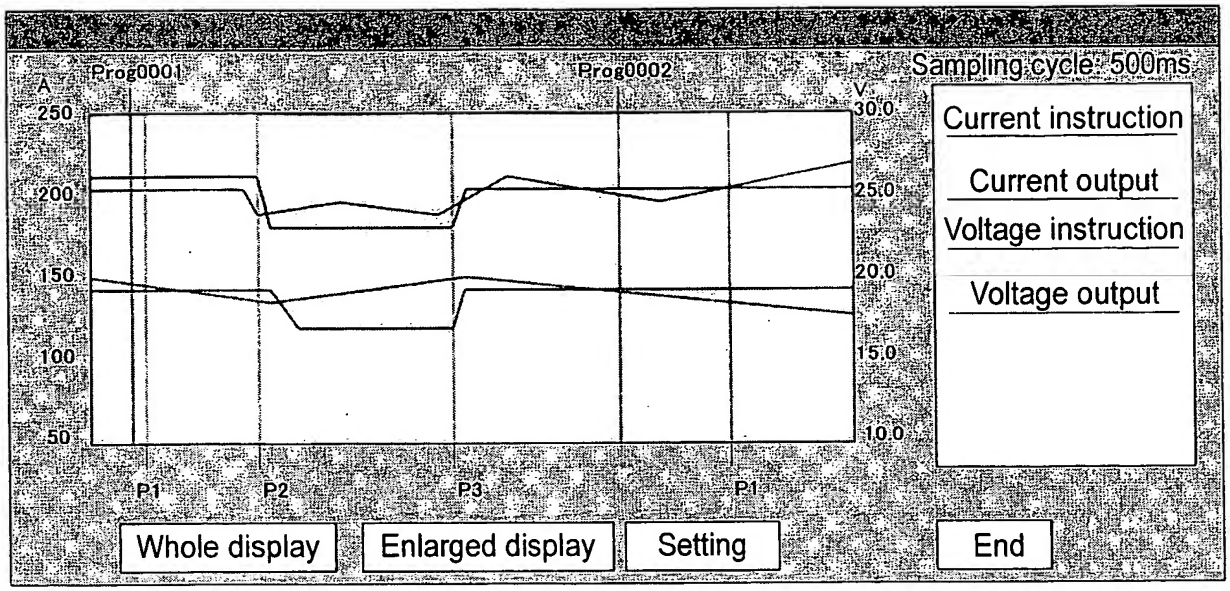
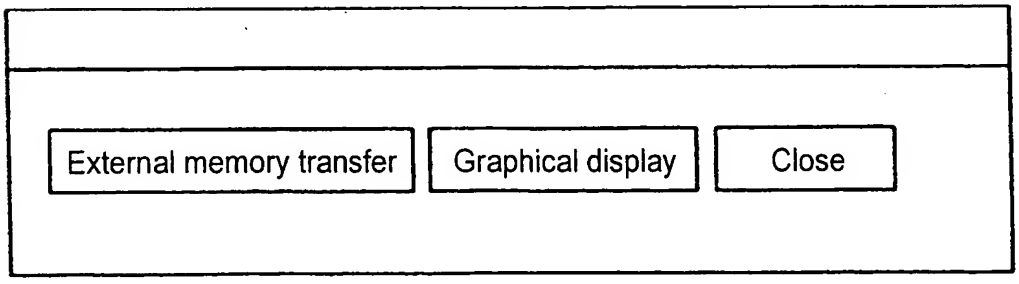

Prog0001
Prog0002
Sampling cycle: 500ms
A
250
200
150
100
50
V
30.0
25.0
20.0
15.0
10.0
Current instruction
Current output
Voltage instruction
Voltage output
P1
P2
P3
P1
Whole display
Enlarged display
Setting
End

FIG. 6


External memory transfer
Graphical display
Close